



Dart Aerospace Ltd.
1270 Aberdeen St
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D4034-043
Job Sheet 199771



Part No: D4034-043

Job Qty: 4 pcs

Part Name: Fwd Upper Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/30/19

Job Tracking No:

Due Date: 9/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Large Fab - Basket - 1	4 pcs	9/20/19		0.00	1.60	Large Fab - 1	
						5 1/2 h	Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	MAZ
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
							Large Fab - 11 (Various)	
110	QC 9	4 pcs	9/20/19		0.00	0.00	QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	DAS
							QC 9 - 43	43
							QC 9 - 50	9-89
							QC 9 - 9	
120	QC 5	4 pcs	9/20/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	DAS
							QC 5 - 43	43
							QC 5 - 49	9-89
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	



Container No: S216456



Part: D4034 - 043

Job No: 199771

Serial No/Batch: S216456

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 09/24/19

Plex 8/30/19 10:00 AM Dart.lajeunesse.marie

				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
130 Packaging 3-1 - Stock - B4B 4 pcs	9/20/19	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	DAS
				Packaging 3 - 20 - B4B	43
				Packaging 3 - 21 - B4B	9-89
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA 4 pcs	9/20/19	0.00 0.00		QC 21 - SA - 21	SEP 24 2019 DAS
				QC 21 - SA - 70	70
				QC 21 - SA - 53	9-89

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: M139015) 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld
 Descriptions: bushing in rib as per dwg
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA004-5
 140 - (QC21- Final Inspection - Work Order Release)

MU# 012043

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	4 pcs (1 ea)	100-Large Fab - Basket - 1	5212094
D4021-9	Bushing	16 pcs (4 ea)	100-Large Fab - Basket - 1	5210140
D4034-1	Rib	4 pcs (1 ea)	100-Large Fab - Basket - 1	5204607
D4034-3	Rib	4 pcs (1 ea)	100-Large Fab - Basket - 1	5205377

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D4021-7	4	0	0
	D4021-9	16	187	0
	D4034-1	4	22	0
	D4034-3	4	22	0
Part Specifications				
Specifications could not be found.				

Plex 8/30/19 10:00 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____		DISPOSITION		DEPARTMENT/PROCESS	
Part No. _____		Rework Scrap Use-as-is		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	
Date: _____		Sequence #: _____		QTY Affected: _____	
Description Work Order Deviation		Disposition		MRB (QS1042)	
Root Cause Operator _____ Manufacturing Process _____ Equip/Tooling _____ Handling/Preservation _____ Material _____ Product Improvement _____ Process Improvement _____ Human Factors _____		FAULT CATEGORY			
		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: _____		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function	
		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	
Completed By		Lead hand / Supervisor		QC / QA Coordinator	